

Work Order ID 82697

82697

Page 1

Thursday, April 05, 2012 7:56:50 AM

Item ID: D3321-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate, LH Fwd RH Mid

Start Date: 4/5/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *R*Date: *12-04-5* Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3321

Rev B

100

100

Waterjet

FLOW CNC Waterjet

1010 16GA.

PURCHASING

Memo

1-Cut as per Dwg

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

0.00

0.00

B
*Jm 12-4-9**(6)*

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B
Jm 12-4-9

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*Sizeloe**(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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$$m/97/2 \rightarrow 228$$

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

QLS → 8/26/17

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

START TIME:

10:20

OVEN TEMPERATURE:

3200F

FINISH TIME:

10:50

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

m117338

(X6)

(X6)

GX

M-L
12/4/20

6

12/4/23

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Identify as per dwg & Stock Location: 198

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/4/23

12/4/23

1204-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 05, 2012 7:56:54 AM

Page 1

Work Order ID: 82697

82697

Parent Item: D3321-1

D3321-1

Parent Item Name: Wearplate, LH Fwd RH Mid

Start Date: 4/5/2012

Required Date: 4/20/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: A05.05.12New issueKJ/JLM

IPP REV:B

12.04.03 NOW MADE IN HOUSE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

163.4200

1.56

9.852632

M1010S16GA

1010/1025 sheet 16GA

**

Jm/IB 12-4-9 (6)

Location

Loc Qty

Loc Code

MAT019

163.42

116791

21.4

117500

16.02

118965

30

121195

96

121195 X 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 82697

Description: WEAR PLATE LH FWD RU MIN

Part Number: D3321-1

Inspection Dwg: D3321-1, Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.266 $\frac{1}{2}$.016	.267	✓		Vern	HB-02
.438 $\frac{1}{2}$.016	.438	✓		Vern	HB-02
.318 $\frac{1}{2}$.016	.318	✓		Vern	HB-02
3.130 $\frac{1}{2}$.010	3.131	✓		Vern	HB-02
3.938 $\frac{1}{2}$.016	3.937	✓		Vern	HB-02
2.390 $\frac{1}{2}$.016	2.395	✓		Vern	HB-02
Ø .180 $\pm .005 - .001$		Ø .181	✓		Vern	HB-02
.38 $\frac{1}{2}$.030	.38	✓		Vern	HB-02
6.012 $\frac{1}{2}$.016	6.014	✓		Vern	HB-02
10.959 $\frac{1}{2}$.016	10.957	✓		Vern	HB-02 PROO-WJ02
13.898 $\frac{1}{2}$.016	13.898	✓		MT	HB-01
15.950 $\frac{1}{2}$.016	15.950	✓		MT	HB-01
19.981 $\frac{1}{2}$.016	19.981	✓		MT	HB-01
24.042 $\frac{1}{2}$.016	24.042	✓		MT	HB-01
32.131 $\frac{1}{2}$.010	32.137	✓		MT	HB-01
40.199 $\frac{1}{2}$.016	40.199	✓		MT	HB-01
48.262 $\frac{1}{2}$.016	48.262	✓		MT	HB-01
56.357 $\frac{1}{2}$.016	56.357	✓		MT	HB-01
57.05 $\frac{1}{2}$.016	57.05	✓		MT	HB-01
.066 $\frac{1}{2}$.016	.058	✓		Vern	HB-02

Measured by: RB / Jm.

Audited by: S

Prototype Approval:

Date: 12-4-9

Date: 12/04/09

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

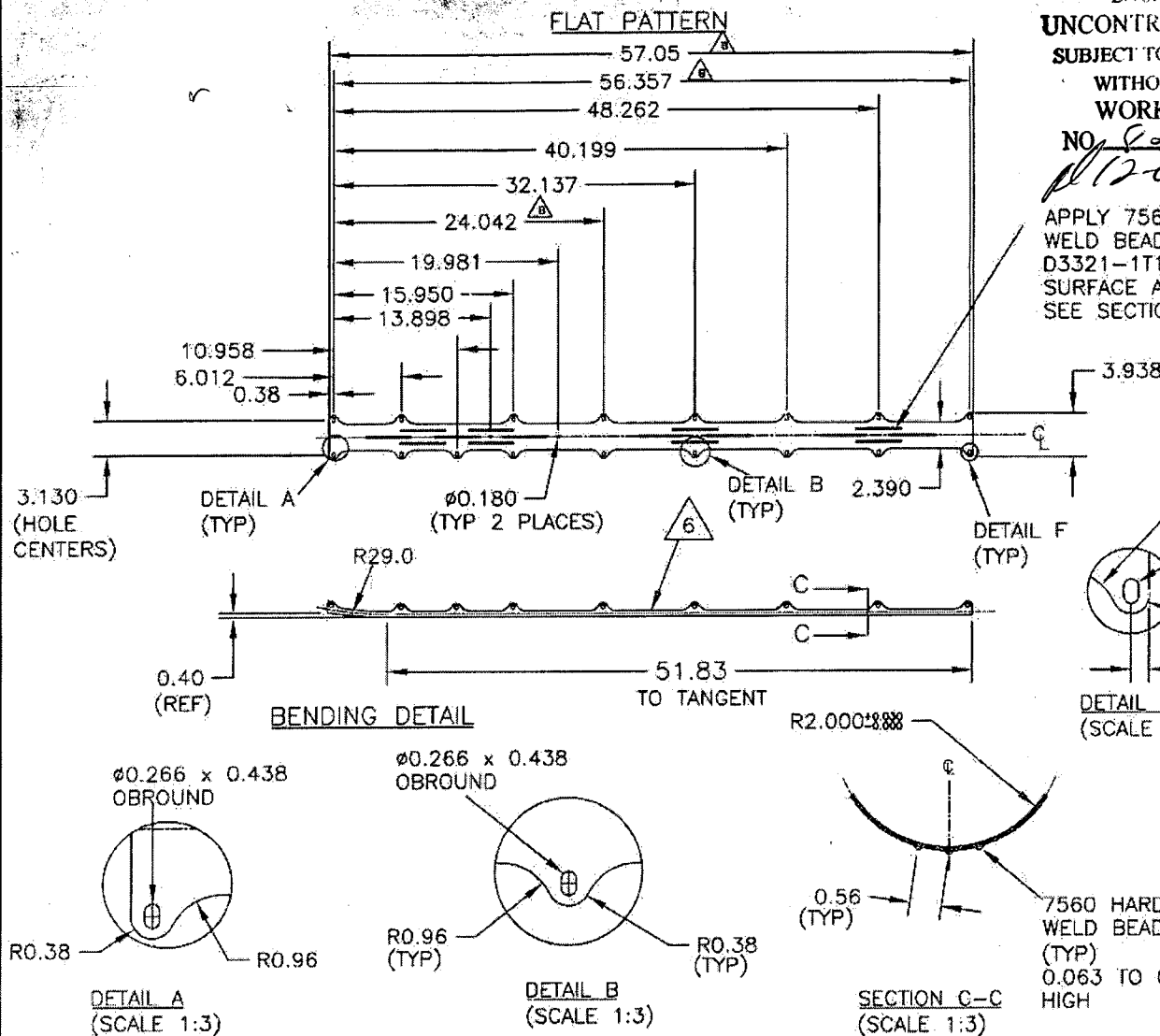
NO. 02697

12-04-5

APPLY 7560 HARDCOAT
WELD BEADS PER
D3321-1T1 ON BOTTOM
SURFACE AFTER FORMING
SEE SECTION C-C

RELEASED

DART



D3321-1 WEARPLATE (SHOWN, -2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3321
DATE	TITLE	SHEET 1 OF 2
05.04.29	WEARPLATE	1:15
A	NEW ISSUE	REV. B
04.10.01		
B	ADJUST GEOMETRY	SCALE
05.04.29		1:15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

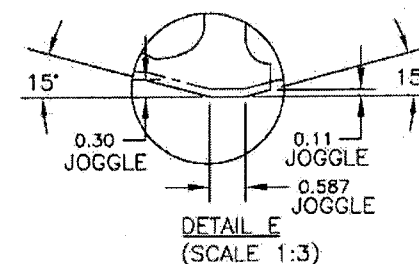
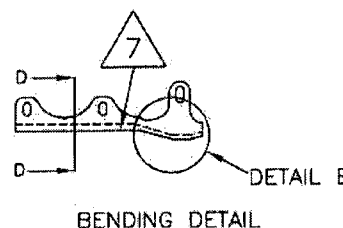
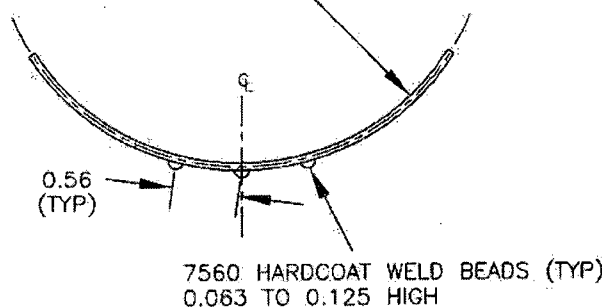
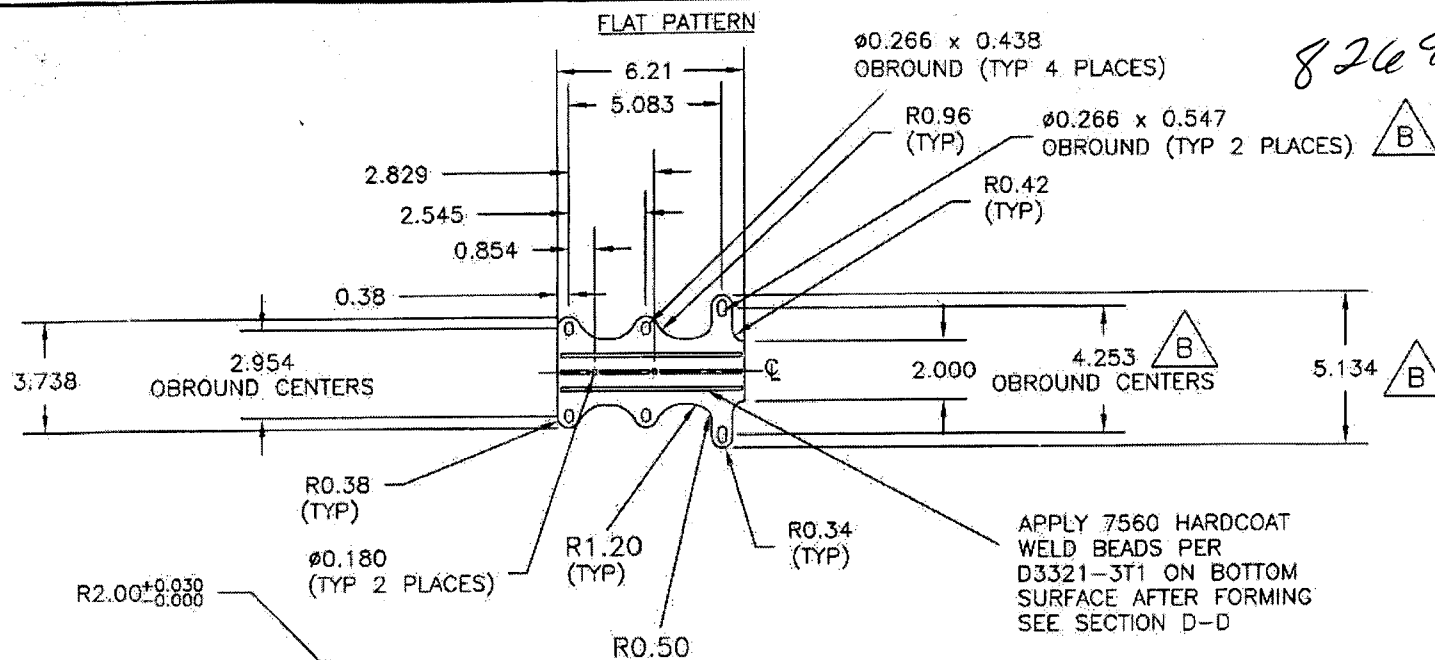
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3321
DATE	05.04.29	TITLE	WEARPLATE	REV. B
		SCALE	1:6	SHEET 2 OF 2



SECTION D-D
(SCALE 1:1.5)

D3321-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
05.11.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries